

order 1816

22 Feb

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada



RBT18538
Job Sheet 170430



Tel (613) 632-5200

Part No: RBT18538

Job Qty: 6 ea

Part Name: Seat Frame Supports



Part Weight: 0 lbs

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18538 Rev2A IPP Rev A 17.12.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/26/18	1/26/18	0.00	0.00	Start Up Stores/Pkg-2		MLL
100	Small Fab	6 pcs	1/26/18	1/26/18	0.00	0.00	Small Fab-4		MLL DAS
110	QC	6 pcs	1/26/18	1/26/18	0.00	0.00	QC4		38
115	Packaging	6 pcs	1/26/18	1/26/18	0.00	0.00	Packaging3		SA 3-89
120	QC21-FG	6 Ea	1/26/18	1/26/18	0.00	0.00	QC21		DAS

Part Op 100 - -Pick bag and tag
Descriptions:

21 MAR 27 2018
9-80

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	RBT18538-1	6	7	0	0
	RBT18538-3	6	6	0	0

Part Specifications

Specifications could not be found.



Container No: S054287



Part: RBT18538

Job No: 170430

Serial No/Batch: S054287

Revision: 2A

Inspector:

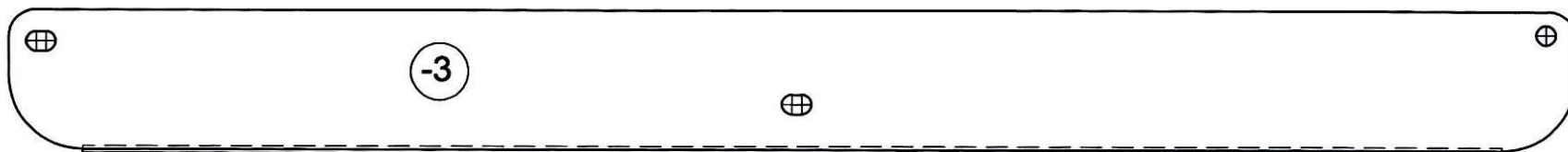
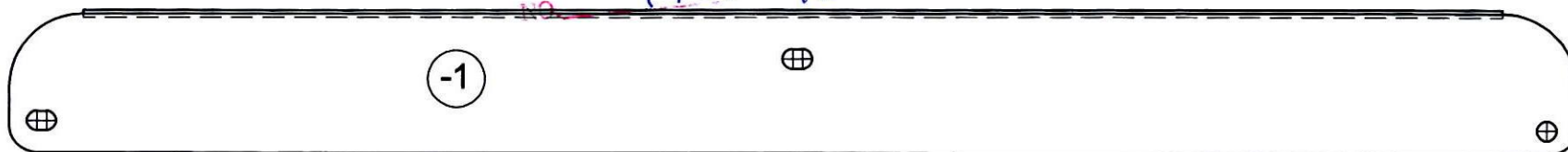
Dart Aerospace Ltd.
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/23/10

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170430 MLS
1801-16

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ORIGINAL TOOL WAS A MACHINED SOLID PART, NOW A FORMED PART.	10/7/10	WP	
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO #.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/8/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



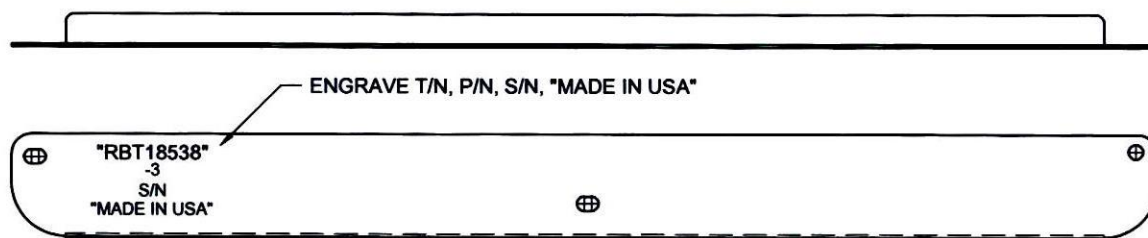
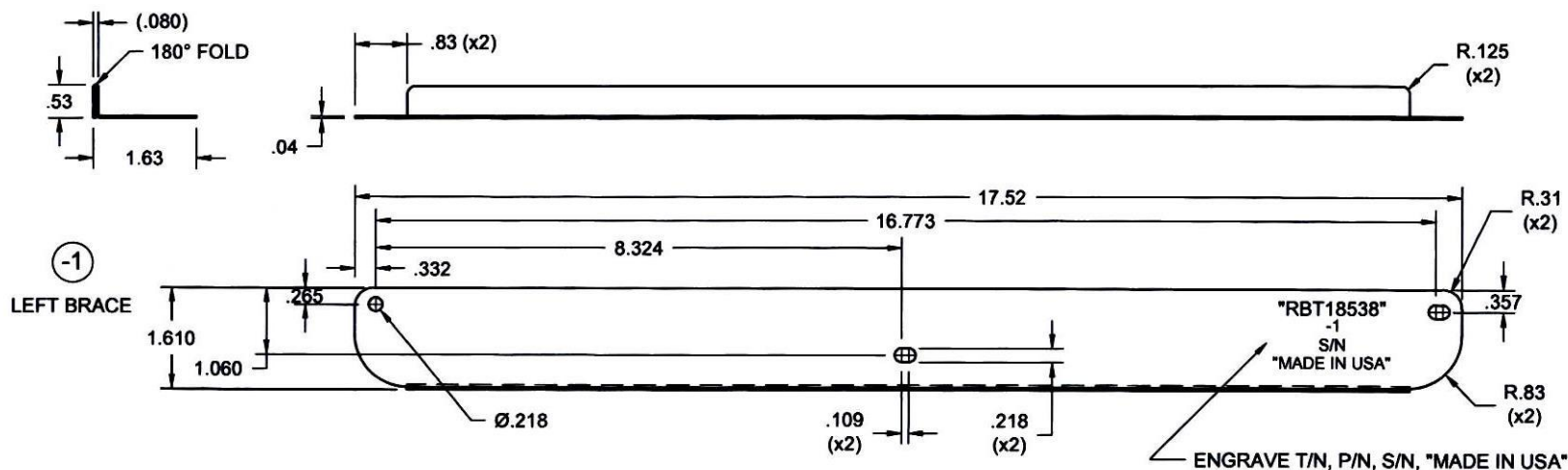
Added B & L & 407 to used on
model 3/20/12 after DW veified
the hole pattern is the same.
No rev done. RJC

ASSY QTY	ASSY #	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	LEFT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2
			-3	1	RIGHT SEAT BRACE	5052	.040 x 2-3/4 x 17-5/8	2

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± .5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 10-7-10
SHEET 1 of 2	
DRAWN BY: PERRITT	
APPROVED: <i>D. Med</i>	
TREAT: FINISH: SPEC:	
USED ON MODEL BELL 206 B & L, 407	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	CH'D MATERIAL THICKNESS FROM .06 TO .04, CH'D CUT OUTS ON END FROM .75 TO .83 (x2), CH'D R.31 (x4) TO R.31 (x2), & ADDED R.83 (x2), CH'D TWO Ø.218 HOLES TO ELONGATED SLOTS, ADDED R.125 (x2) TO LIP PER D.W.	1/6/11	RJC	
2A	ADDED ENGRAVE NOTE -1 & -3 PER R.W.	2/17/11	RJC	RW



(-3)
RIGHT BRACE
(DIMENSIONALLY OPPOSITE LEFT BRACE)

RED BARN MACHINE	
TITLE SEAT FRAME SUPPORTS	
DWG NO. RBT18538	REV 2A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 XX ± .01 X ± .1	
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: PERRITT APPROVED: <i>D. Weir</i> HEAT TREAT: CLEAR ANODIZE SPEC: MIL-A-8625F, TYPE II, CLASS I USED ON MODEL: BELL 206 B & L, 407	
SCALE NTS	DATE 10-7-10
SHEET 2 of 2	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					